

Work Order ID 86195

86195

Page 1

Item ID: D2275

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bushing

Stop ***NS2***

Start Date: 22/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/22

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2275	Rev C								
100		0.00							
100	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Machine as per Folio FA 213 Tumble & deburr all sharp edges								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

DAS
04
9-89

DAS
04
9-89

J. M. 13.01.02 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86195

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June-22-12 1:56:00 PM

Item ID: D2275

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bushing

Stop ***NS2***

Start Date: 22/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *WMA*

0.00

130

Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL ***

20 *0* *13-01-03*

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

13/1/12

W 13-01-03

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June-22-12 1:56:03 PM

Page 1

Work Order ID: 86195

86195

Parent Item: D2275

D2275

Parent Item Name: Bushing

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP E02.03.27Added in house machiningNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.250		Purchased	No			100	f	25.6600	0.1667	3.509474			

M6061T6R1 250

6061-T6 Round Bar 1.250

**

Location

MAT013

113457

113550

Loc Qty

25.66

5.66

20

Loc Code

12-12-30

1.833

DAS
04
8-89

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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PREPARED	B. Williams		DART AERO ACCESSORIES INC	
CHECKED	APPROVED	VICTORIA INTERNATIONAL AIRPORT, CANADA		
DATE	SEP. 29, 1994	D2275	REV. C	
TITLE		BUSHING	SHEET 1 OF 1	
B		Nov. 15, 1994	C'BORE WAS COUNTER SINK	
C		96.09.12	C'BORE WAS 0.300 DEEP	

RELEASED
R 96.09.12 BLS

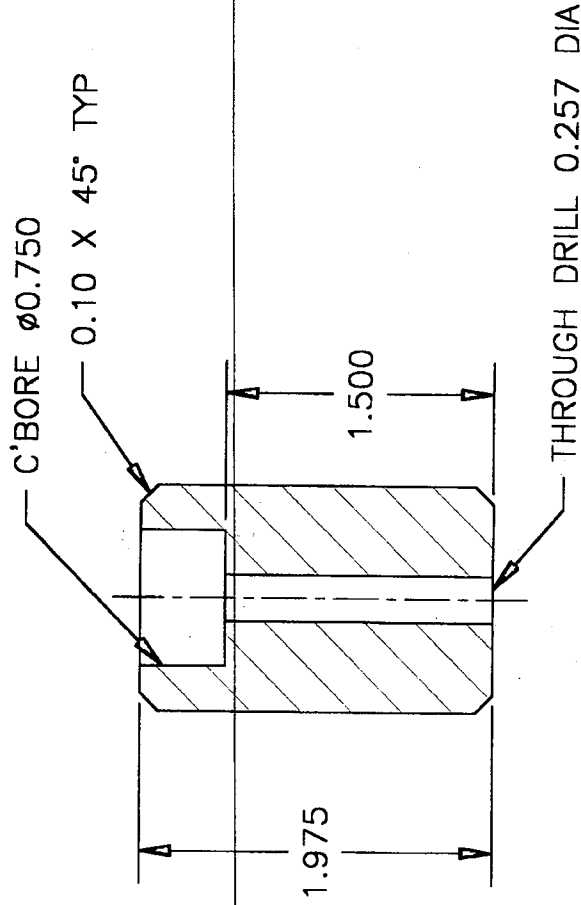
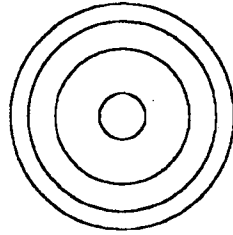
UNDER REVIEW

96.03.15 CP

DESIGN OK, BUT CHECK WITH
CTR BEFORE MANUFACTURE

OK CP 11-08.17

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86195 MLJ
12/06/22



MATERIAL: 6061-T6 1.25 BAR STOCK
(QQ-A-200/g)

W/O:		WORK ORDER CHANGES					
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